



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2170
Job Sheet 185031



Part No: D2170

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2170 REV.n/a IPP REV:A 13.09.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/12/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	4 pcs		11/12/18	0.00	0.40	Small Fab-9		
120	QC	4 pcs		11/12/18	0.00	0.00	QC5		
130	Powdercoat	4 pcs		11/12/18	0.01	0.40	Powdercoat1		
140	QC	4 pcs		11/12/18	0.00	0.00	QC3		
150	Packaging	4 pcs		11/12/18	0.00	0.00	Packaging3 Large Fab		
160	QC21-SA	4 Ea		11/12/18	0.00	0.00	QC21		

Part Op 100 - 1- Pick parts 2- Assemble as per Dwg:
Descriptions: 130 - start time: 10:10 oven temp: 320° finish time: 10:40 M-BB 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2170-1	Bracket	4 Ea (1 ea)	90-Start up Operation	<u>5124914</u>
D2170-3	Bracket	4 Ea (1 ea)	90-Start up Operation	<u>5122219</u>
MS20470AD4-4	Rivet, Universal Head	24 Ea (6 ea)	90-Start up Operation	<u>5106821</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2170-1	4	0	0
	D2170-3	4	0	0
	MS20470AD4-4	24	5,563	0



Container No: S126716



Part: D2170

Job No: 185031

Serial No/Batch: S126716

Revision: N/A

Inspector:

Exp Date:

Instructions:

Date: 11/12/18

Plex 10/22/18 10:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

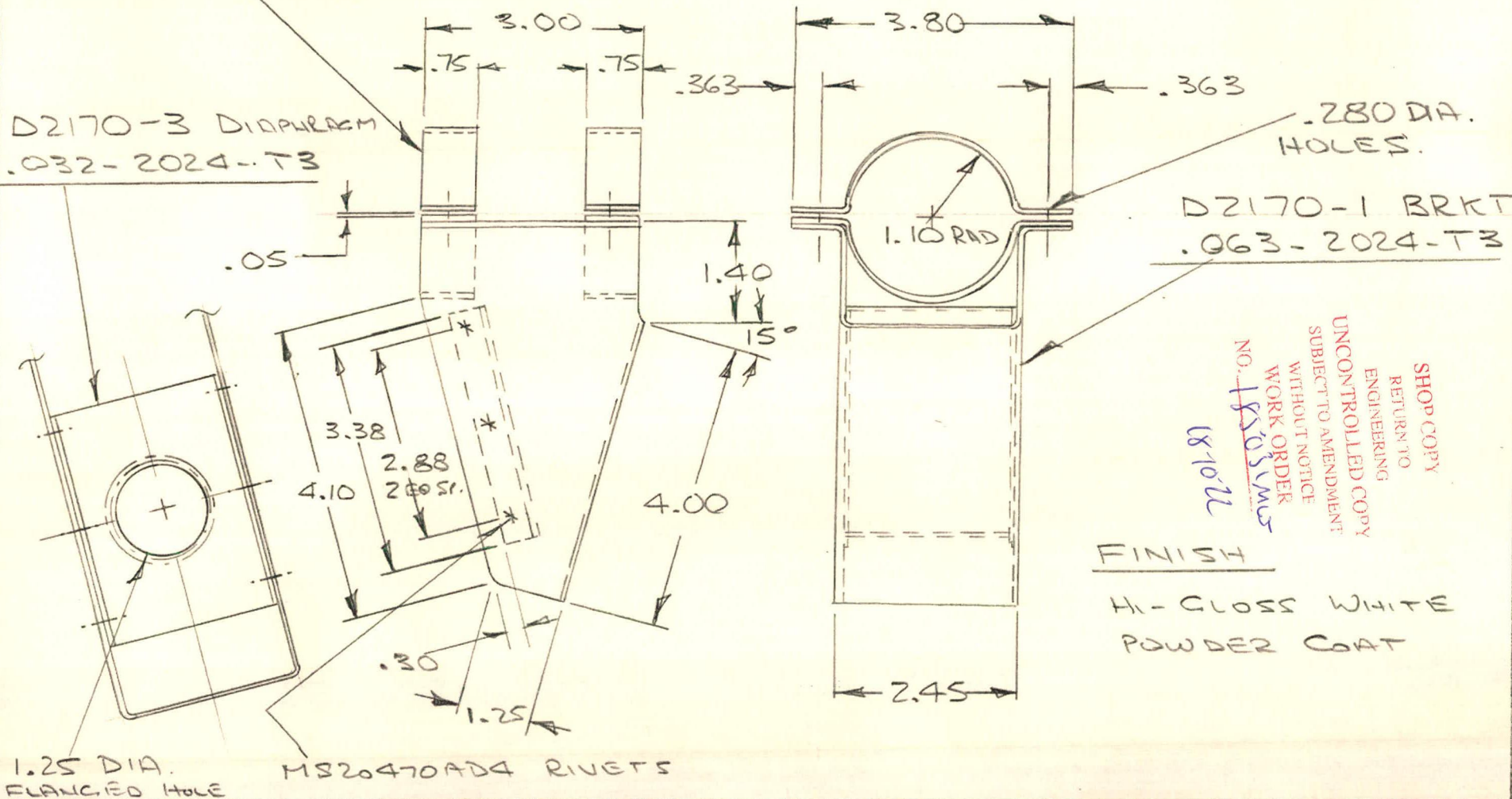
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D2171 CLAMP (4) .063 - 304 STAINLESS ST'L

D2170-3 DIAPHRAGM
.032 - 2024 - T3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 18303146
18-10-22

FINISH
HI-GLOSS WHITE
POWDER COAT

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO SYSTEMS INC.		CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA CLIENT TITLE STEP BRACKET DETAILS CODE DWG NO. D2170/D2171 SCALE NTS SHT 1 OF 1
	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		DATE		
	GENERAL		DESIGN		
	LIMITS		STRESS		
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 2742 5. HOLES PER AND 10387		1. TOLERANCES - XX ± .030 XXX ± .010 2. ANGLES 1° 3. PARALLELISM 1.0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		CHECKED CLIENT	

